



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBEA62310
Job Sheet 188422



Part No: RBEA62310

Job Qty: 3 pcs

Part Name: AS350/355 Engine Strut



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/9/19

Job Tracking No:

Due Date: 1/31/19

Created By: Marie Lajeunesse

Type: ~~SOLD~~ *SHK*

Description:

Note: DWG RBEA62310 Rev 1A IPP Rev A 18.01.16 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	3 pcs	1/31/19	1/31/19	0.00	3.00	Small Fab - 1		<i>DAS</i> <i>71</i> <i>9-89</i> <i>19-4-23</i>
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	3 pcs	1/31/19	1/31/19	0.00	0.00	QC 5 - 10		<i>DAS</i> <i>30</i> <i>APR 23 2019</i>
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
130	Packaging 3-1 - Stock - B4B	3 pcs	1/31/19	1/31/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



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CANADA
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Container No: S174410



Part: RBEA62310

Job No: 188422

Serial No/Batch: S174410

Revision: 1A

Inspector:

Exp Date:

Instructions:

Date: 04/23/19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER :							
Misidentified ☐	☐ Past Due								

				Packaging 3 - 8 - B4B	DAS 30
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
140	QC 21 - SA	3 pcs	1/31/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70

Part Op 110 - 1-Cut -07 and -015 to fit as per note 1 2-Stick -07 to -01 3-Stick -015 to -09 4-Discard -17 turnbuckle hooks
 Descriptions: 5-Assemble as per DWG. Sheet 1
 120 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: *GA 135*)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
30125T403	Turn Buckle Body	3 pcs (1 ea)	110-Small Fab - 1	<i>8096703</i>
8997K11	Cushion w/Adhesive Back 60A durometer	.1650 sf (.055 ea)	110-Small Fab - 1	<i>5056844</i>
RBEA62310-01	Top Weldment	3 pcs (1 ea)	110-Small Fab - 1	<i>5149117</i>
RBEA62310-09	Bottom Weldment	3 pcs (1 ea)	110-Small Fab - 1	<i>5157320</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	30125T403	3	5	0
	8997K11	0	1	0
	RBEA62310-01	3	0	0
	RBEA62310-09	3	4	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

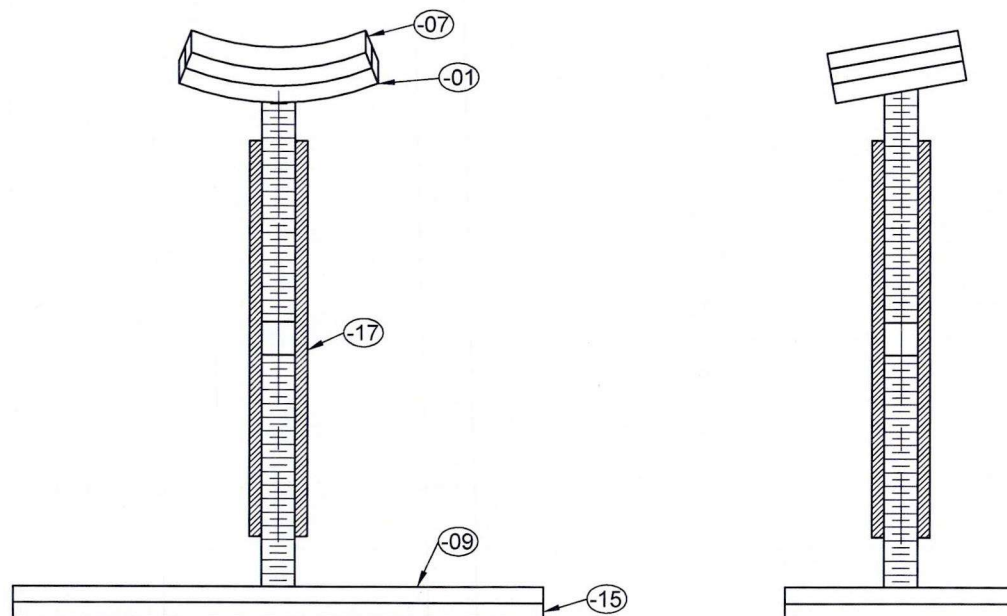
QA Closed: _____ Date: _____

Work Order update only ☐

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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	DELETED -05 10° ANGLE PER S.E. CH'D -03 BOM INFO FROM 1018 PER R.W.	5/21/12	RJC	SE
1A	CH'D TOOL NAME WAS ENGINE SUPPORT STRUT IS AS350/355 ENGINE STRUT.	11/15/16	RJC	RW



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 188922 MC5
1901-10

NOTES

1. CUT -07 & -15 CUSHIONS TO FIT.
2. DISCARD -17 TURNBUCKLE HOOKS.

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-01	1	TOP WELDMENT			2
	1		-03		TOP PLATE	DOM TUBE	4 X .120 WALL X 1	3
	1		-05		R/H ALL THREAD	PLAIN STEEL	1/4-20 UNC x 1-13/16 MCMaster-CARR #98750A017	4
	1		-07		CUSHION WITH ADHESIVE BACK	BLACK RUBBER	1/8 x 1 x 1-7/16 REF. (MCMaster-CARR #8997K112)	1
			-09	1	BOTTOM WELDMENT			5
1			-11		BOTTOM PLATE	1018	1/8 x 1-3/4 x 4	6
1			-13		L/H ALL THREAD	PLAIN STEEL	1/4-20 UNC x 1-3/4 REF. (MCMaster-CARR #95625A003)	7
1			-15		CUSHION WITH ADHESIVE BACK	BLACK RUBBER	1/8 x 1-3/4 x 4 REF. SEE -07	1
		B/O	-17	1	TURN BUCKLE BODY	ALUMINUM	1/4-20 UNC x 3 MCMaster-CARR#30125T403	1

RED BARN MACHINE

TITLE		AS350/355 ENGINE STRUT	
DWG NO.		RBEA62310	
REV		1A	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: PERRITT	
TOLERANCES ON:		APPROVED <i>D Weil</i>	
DECIMALS .XXX ± .005		METRIC REF. .XXmm ± .1mm	
.XX ± .01		FRACTIONS ± 1/32	
.X ± .1		ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR. 015 R		SPEC	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON MODEL	
SCALE NTS		DATE 3-10-10	
		SHEET 1 of 7	